

HAZ ONLY

Dart Aerospace Ltd.



Date: Friday, 27/10/2006 2:43:46 PM  
User: Linda Lacelle

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 29210		
Estimate Number	: 10699		
P.O. Number	: N/A	Part Number	: D3391025
This Issue	: 27/10/2006 S.O. No. : N/A	Drawing Number	: D3391 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: E
Previous Run	: 27687	Material	: S/A
Written By	:	Due Date	: 30/11/2006 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev: C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D6014090	ALUMINUM EXTRUSION
		
Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s) ALUMINUM EXTRUSION Pick: Qty Part Number Description Batch 1 D6014-090 Extrusion B26546 Identify as D3391-3		



MS 06/10/28 1

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
		
Comment: MORI SEIKI CNC LATHE LARGE Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: E		

MS 06/10/28 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

MS 06/10/28 1

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS 1-Machine as per Folio FA 599 Rev: ____ & Dwg D3391 Rev: ____ 2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 3-Deburr		

Ed 07/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/07	#2.0	major date markings were discovered in Bond out two section						
07/02/07	#4.0	3.9 mould white D.U. aft pilot hole - hole off by 0.05"						

NOTE: Date &amp; initial all entries

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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/02/12

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

7.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 7-2-8

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/02/12

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

Tools: rill

BE 07-02-09

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/02/12

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

EL/YL

07/02/12 ①

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Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



m103/41



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SR/yl

07/02/13

(1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

yl 7/2/14 (1)

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	100732

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

yl

07/02/14 x1

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	102642

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	17905

or NAS1330C3KB266

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	17905
or NAS1330C3KB316			

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	30119

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	161390

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	103344

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	103481

yl 07/02/14

W/O:		WORK ORDER CHANGES					
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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

102672

Sikaflex expiry date:

02/07

25.0

QC5

INSPECT WORK TO CURRENT STEP



ml 07 02 14



(1)

Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A ass'ed on tube

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 207/02/14

ATTN  
STOP  
ENK

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29210
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.495	✓			
88.93	+/-0.030	88.93	✓			
* 44.995	+/-0.030	SEE w/lo #		29213		
3.200	+/-0.010	3.205	✓			
1.526	+0.000/-0.030	1.526	✓			
0.200	+/-0.010	0.203/0.210	✓			
7.500	+/-0.010	7.497	✓			
27.750	+/-0.010	27.756	✓			Tape measure
31.750	+/-0.010	31.750	✓			Tape measure
35.250	+/-0.010	35.250	✓			Tape measure
0.400	+/-0.010					
* Ø0.208	+0.005/-0.001	See w/lo #		29213		
3.300	+/-0.010	3.301/3.297	✓			
0.200	+/-0.010	0.203/0.210	✓			
3.520	+/-0.010	3.519	✓			
0.687	+0.010/-0.000	0.686	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	0.487	✓			

<b>Measured by:</b> MB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 06/10/29	<b>Date:</b>	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	

**Dart Aerospace Ltd**

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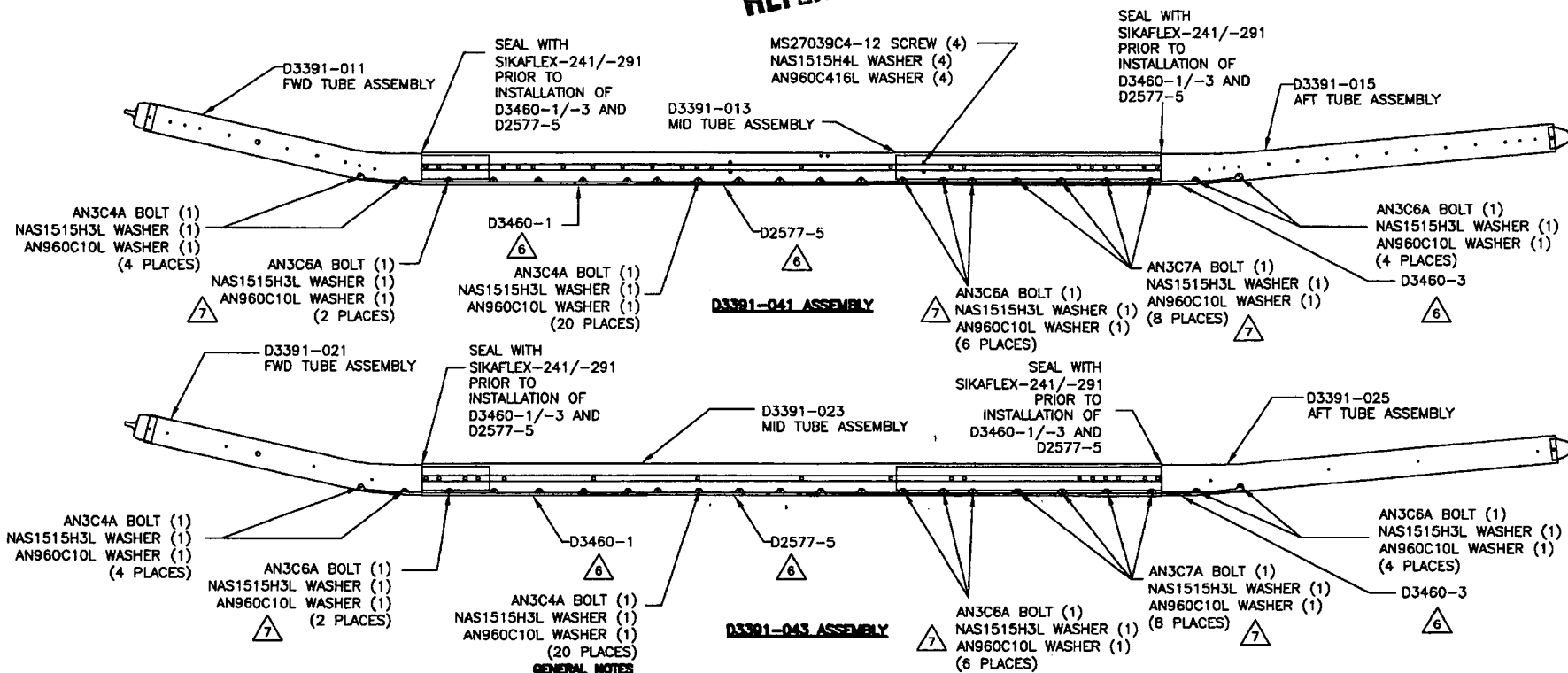
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**REFERENCE ONLY**



**D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

- GENERAL NOTES**
- 1) ALL DIMENSIONS ARE IN INCHES
  - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
  - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.  
C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
  - 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
  - 7) DO NOT TORQUE, HAND TIGHTEN ONLY

**D**

**RELEASED**

06-05-03

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E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.04.25	TITLE
		D3391
		DRAWING NO.
		D3391
		REV. E
		SHEET 1 OF 5
		SCALE
		2 FLOAT SKIDTUBE
		NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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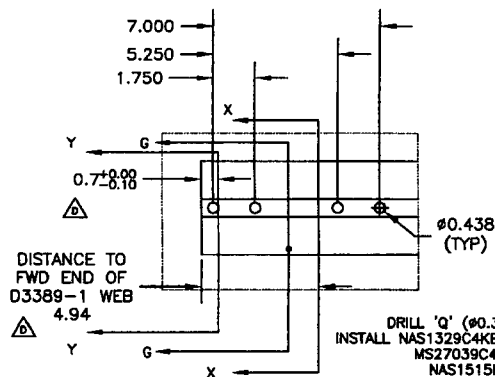
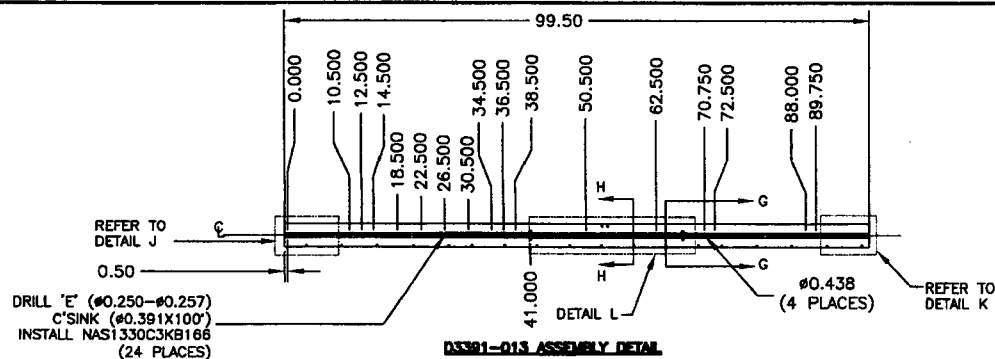
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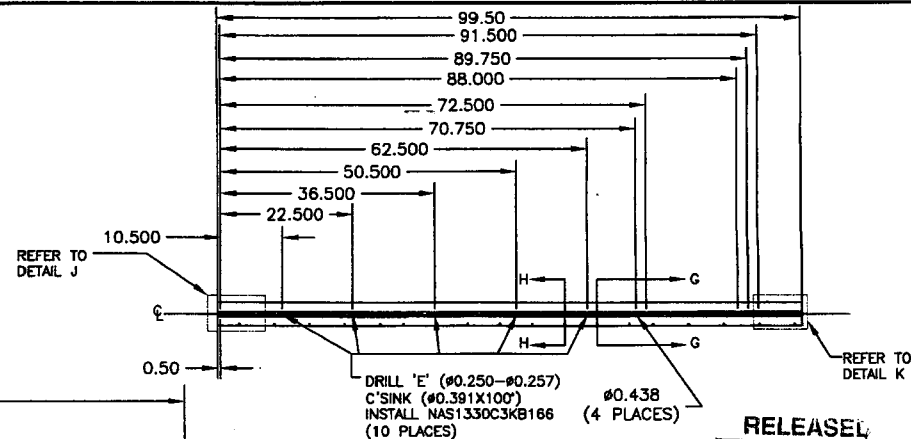
**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

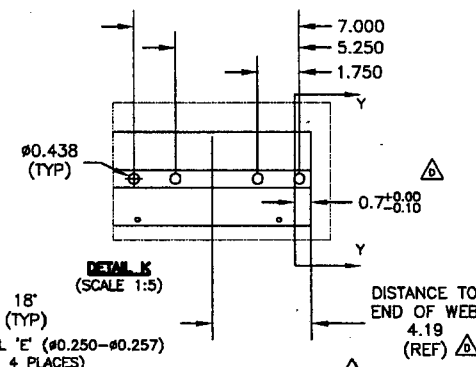
D3391-013/-023 MID TUBE ASSEMBLY

1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION

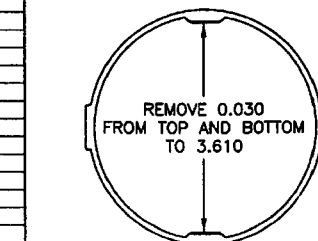
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



**D3391-023 ASSEMBLY DETAIL**

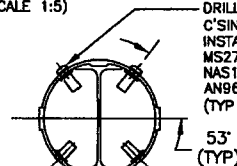


**SECTION L-L**  
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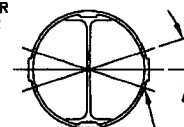


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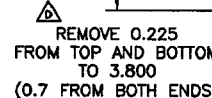
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(SCALE 1:4)



**SECTION U-U**  
(SCALE 1:4)



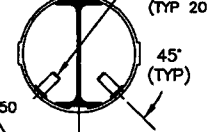
**SECTION Y-Y**  
(SCALE 1:4)



**SECTION Q-Q**  
(SCALE 1:4)



**SECTION H-H**  
(SCALE 1:4)



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DESIGN  
PH  
CHECKED  
#

DRAWN BY  
PH  
APPROVED  
#

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, OH

DRAWING NO.  
D3391

TITLE  
412 FLOAT SKIDTUBE

REV. E  
SHEET 3 OF 5  
SCALE  
1:20

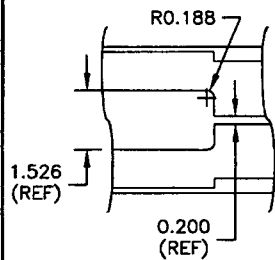
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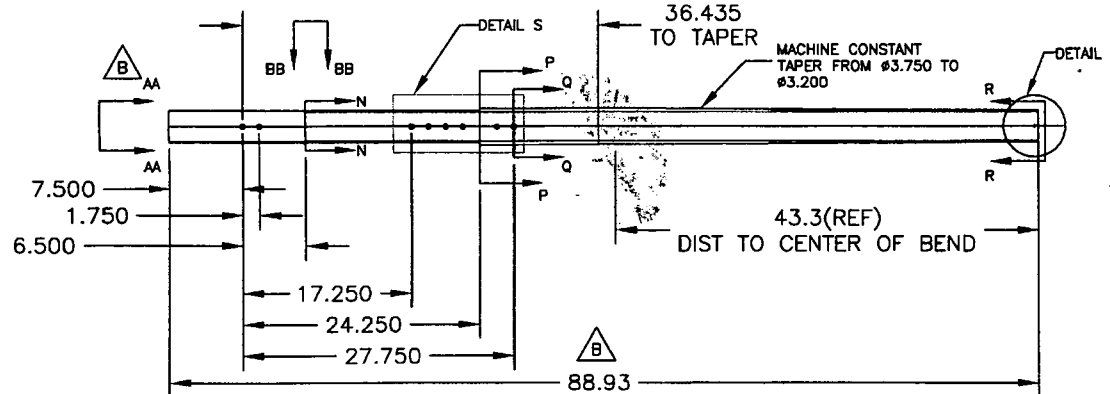
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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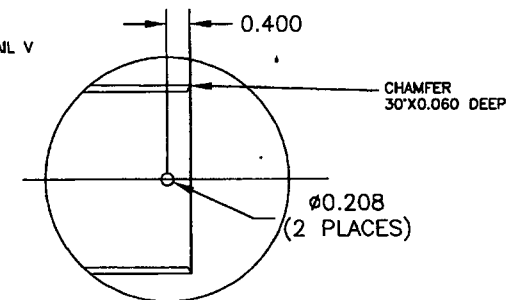
NOTE: Date & initial all entries



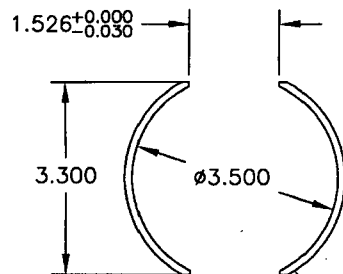
**VIEW BB-BB**  
(SCALE 1:3)



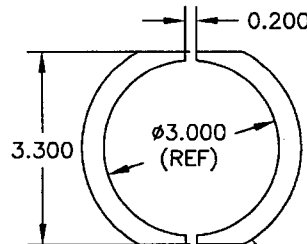
**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



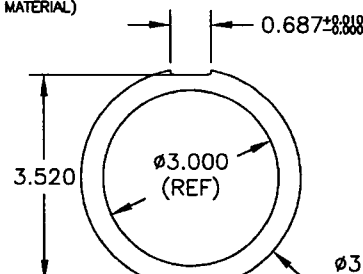
**DETAIL V**  
(SCALE 1:2)



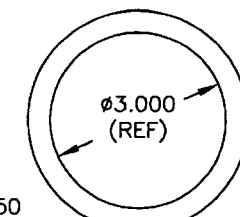
**SECTION AA-AA**  
(SCALE 1:2)



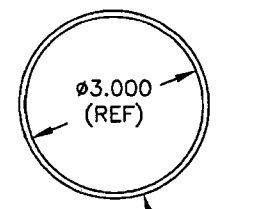
**SECTION N-N**  
(SCALE 1:2)



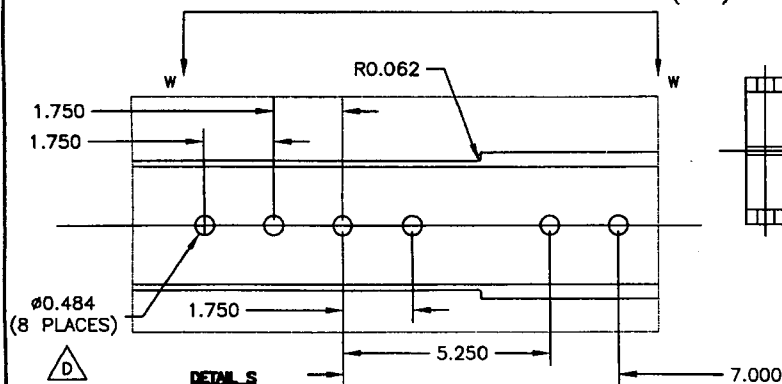
**SECTION P-P**  
(SCALE 1:2)



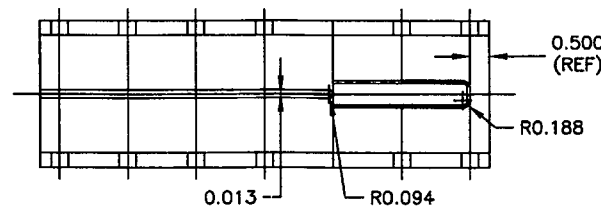
**SECTION Q-Q**  
(SCALE 1:2)



**SECTION R-R**  
(SCALE 1:2)



**DETAIL S**  
(SCALE 1:3)



**VIEW W-W**  
(SCALE 1:3)

RELEASED

26-05-03

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DESIGN	PH	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. E
CHECKED	PH	APPROVED	PH	DRAWING NO. D3391	SHEET 4 OF 5
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	SCALE	1:12

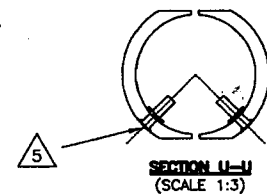
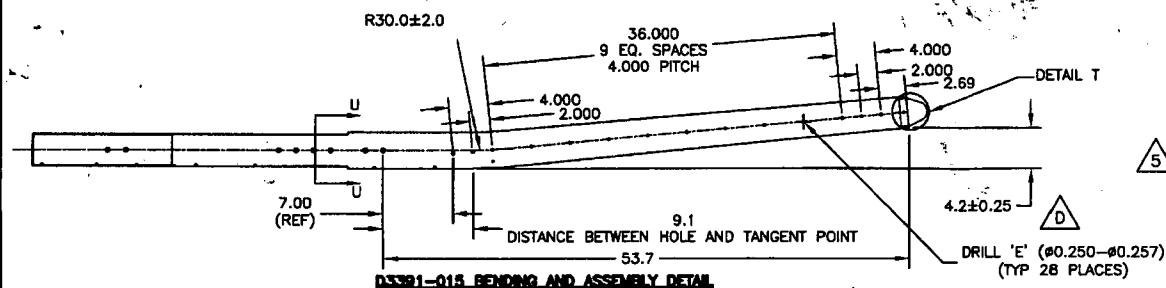
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

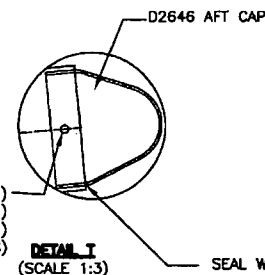
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

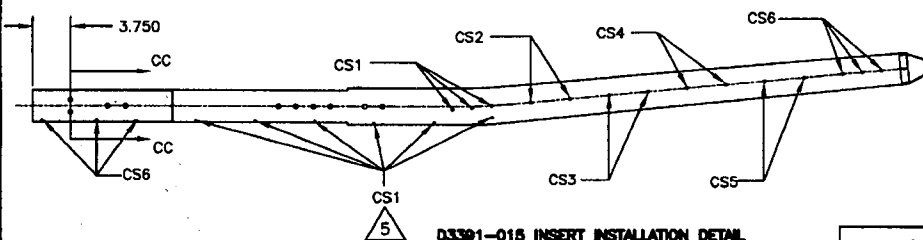
NOTE: Date & initial all entries



AN3C4A BOLT (1)  
NAS1515H3L WASHER (1)  
AN960C10L WASHER (1)  
(2 PLACES)



SEAL WITH  
SIKAFLEX-241/-291

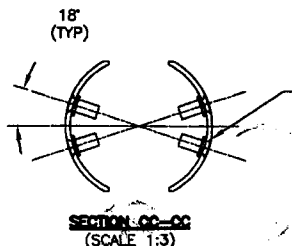


C'SINK AND INSTALL AESS10KBXXX AND/OR  
NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS  
FOLLOWS

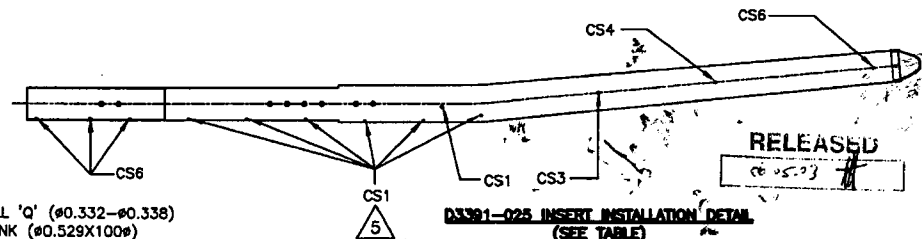
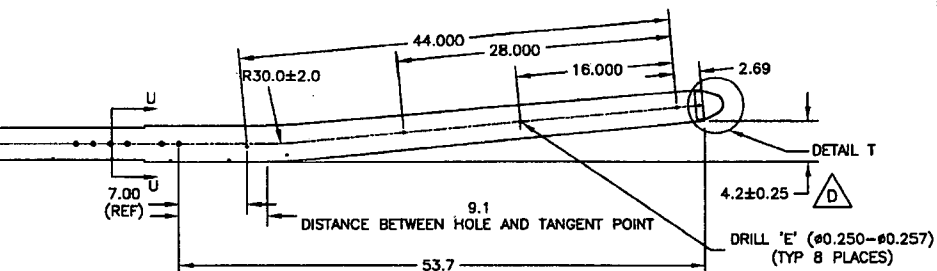
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	PIN
CS1	18	14	Ø0.425	AESS10KB366
CS2	4	2	Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KE316
CS4	4	2	Ø0.391	NAS1330C3KE2E6
CS5	4	2	Ø0.391	NAS1330C3KE216
CS6	12	8	Ø0.391	NAS1330C3KE1E6

# D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB286	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4	2	NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100#)  
NAS1330C4KB151 INSERT (1)  
(4 PLACES)



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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	
CHECKED	APPROVED	DRAWING NO. D3391	REV. E SHEET 5 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries